

Date: Monday, 2/5/2007 4:02:12 PM  
 User: Kim Johnston

## Process Sheet

|  |                                      |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEB                   |
| Job Number : 30649                             |                                      |
| Estimate Number : 10498                        |                                      |
| P.O. Number : <i>N/A</i>                       | Part Number : D2739                  |
| This Issue : 2/5/2007 S.O. No. : <i>N/A</i>    | Drawing Number : D2739 REV C         |
| Prsht Rev. : NC                                | Project Number : N/A                 |
| First Issue : 2/5/2007 Type : LANDING GEAR     | Drawing Revision : C                 |
| Previous Run : 30555                           | Material : <i>N/A</i>                |
| Written By : _____                             | Due Date : 2/23/2007 Qty: 4 Um: Each |
| Checked & Approved By : <i>07.02.06</i>        |                                      |
| Comment : Est Rev: C 02.11.28 Reformat KJ      |                                      |
| Est Rev: D 06-03-21 As Per Rev C JLM           |                                      |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                         |
|-----|-----------|-------------------------|
| 1.0 | D26005108 | Extrusion 'I Beam' thin |
|-----|-----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web

*B 24410**pmc / 5D 7-2-13*

|     |                |                         |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

12-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.

5-Dburr

*pmc / 5D 7-2-13*

|     |     |                              |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

*BE 07.02.14*

|     |                 |                            |
|-----|-----------------|----------------------------|
| 4.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*pmc / 5D 7-2-14*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/10/17

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 4:02:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 30649

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-02-26

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: LG

BE 07-02-26

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/27

Job Completion



U 07.02.27

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                        |          |  |  |  |  |
|------------------------|----------|--|--|--|--|
| DESIGN<br>RH           |          | DRAWN BY<br>RH   |  | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |  |
| CHECKED<br>[Signature] |          | APPROVED<br>[Signature]                                  |  | DRAWING NO. D2739<br>REV. C<br>SHEET 1 OF 1  |  |
| DATE<br>06.01.05       |          | TITLE<br>WEB   |  | SCALE<br>1:15                                |  |
| A                      | 98.04.16 | NEW ISSUE  |  |  |  |
| B                      | 98.11.18 | CHANGE HOLES FOR COMPATABILITY<br>WITH AIRCRUISER FLOATS |  |  |  |
| C                      | 06.01.05 | ADD/MOVE HOLES FOR COMPATABILITY<br>W/APICAL FLOATS      |  |  |  |

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30649

D2739 WEB

|    |           |  |
|----|-----------|--|
| 1) | MATERIAL: | MAKE FROM D2600-5 EXTRUSION                            |
| 2) | FINISH:   | ACID ETCH, ALODINE PER DART QSI 005 4.1                |
| 3) |           | ALL DIMENSIONS ARE IN INCHES                           |
| 4) |           | TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED |

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